

Date:  
User:Monday, 17/11/2008 10:41:45 AM  
Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: TURNING DETAIL FOR D2896-1
<b>Job Number</b>	: 43480		
<b>Estimate Number</b>	: 13236		
<b>P.O. Number</b>	:	<b>Part Number</b>	: DSK080
<b>This Issue</b>	: 17/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b>	: DSK080 REV.A
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b>	: A
<b>Previous Run</b>	: 38133	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 24/11/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JUD 08.11.17</u>		
<b>Comment</b>	: est rev A. 08.03.13    new issue    EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6104011	17-4 SS Roundbar 6.50"OD
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**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 10.0000 Each(s)

Billet

Batch: 338214

SA 08/12/02

(10)

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE  
Turn blank as per Folio FA167

PP 08/12/15

SA 25/12/02

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

PP 08/12/15

SA 08/12/02

(10)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

ml 08/12/16

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
Identify and Stock in Kanban  
Location: \_\_\_\_\_

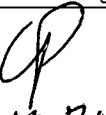


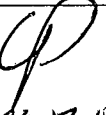
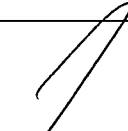
ml 08/12/16

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DSK 080 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>43480</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.12.02	2	- .00 dimension is .005 under tolerance R.C. Blank was too short. Cut by supplier. Blank looks like it was <del>the</del> last cut off of the material.	 08.12.02 Jv DS 042	Acceptable	 08/12/02	 08.12.02.	 08.12.02 Jv DS 042	 08.12.02

NOTE: Date & initial all entries

Date: Monday, 17/11/2008 10:41:45 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2896-1

Job Number: 43480

Part Number: DSK080

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43480
<b>Description:</b> Turning Detail for D2896-1		<b>Part Number:</b> DSK080
<b>Inspection Dwg:</b> DSK080	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.482	3.482	3.482	3.483	3.482
B	3.990	4.010		4.000	4.000	4.000	3.999	4.000
C	3.825	3.845		3.836	3.820	3.836	3.836	3.836
D	0.718	0.738		0.732	0.738	0.737	0.726	0.726
E	0.090	0.110		0.095	0.090	0.090	0.098	0.098
F	3.705	3.725		3.714	3.707	3.713	3.714	3.714
G	1.360	1.380		1.3696	1.370	1.370	1.370	1.370
H	1.250	1.260		1.258	1.258	1.258	1.258	1.258
I	6.490	6.510		6.500	6.500	6.500	6.500	6.500
J	0.022	0.042		0.031	0.031	0.031	0.031	0.031
K	0.240	0.260		0.250	0.250	0.250	0.250	0.250
L	0.107	0.127		0.117	0.118	0.117	0.117	0.117
M								
N								
O								
P								

<b>Measured by:</b> S.A. / 10/10	<b>Date:</b> 08/12/02
<b>Audited by:</b> MK	<b>Date:</b> 08/12/16
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

DART AEROSPACE LTD		Work Order:	43480
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.483	3.482	3.483	3.481	3.48
B	3.990	4.010		4.009	3.999	4.000	4.000	4.00
C	3.825	3.845		3.836	3.836	3.837	3.837	3.837
D	0.718	0.738		.732	.730	.730	.730	.730
E	0.090	0.110		.098	.098	.098	.098	.098
F	3.705	3.725		3.714	3.714	3.715	3.716	3.718
G	1.360	1.380		1.370	1.370	1.370	1.370	1.370
H	1.250	1.260		1.258	1.258	1.258	1.258	1.258
I	6.490	6.510		6.500	6.500	6.500	6.500	6.500
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.240	0.260		.250	.250	.250	.250	.250
L	0.107	0.127		.117	.118	.116	.117	.117
M								
N								
O								
P								

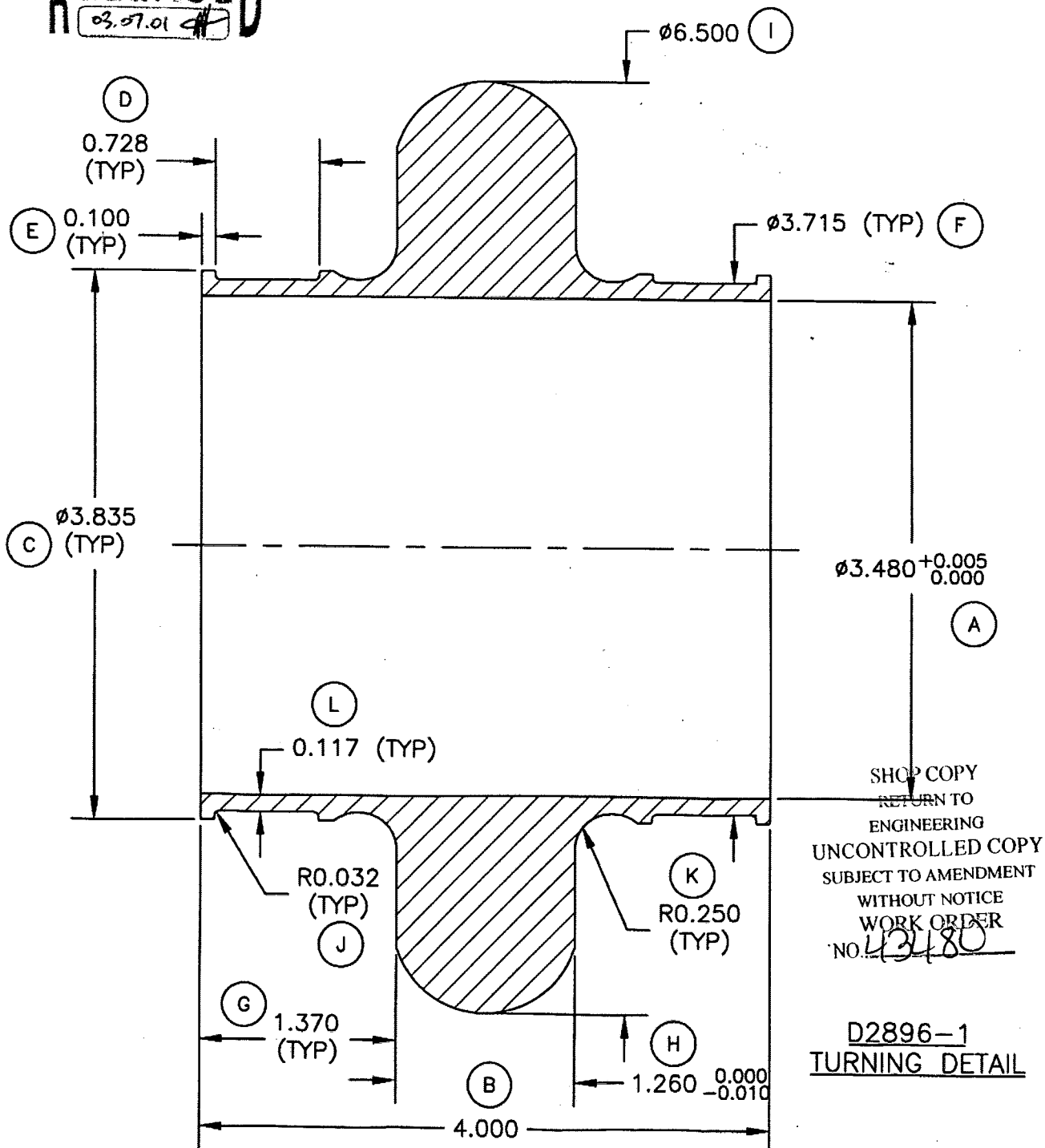
Measured by:	SA / [Signature]	Date:	08/12/02
Audited by:	[Signature]	Date:	08/12/16
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM [Signature]	[Signature]



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01 [Signature]



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